

Work Order ID 118461

Monday, October 06, 2014 2:36:16 PM

118461

Page 1

Item ID: D412-760-113

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 10/6/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/7/2014 Req'd Qty: 1.00 ***1***

Customer: CHAWK02

Reference: RMA RA111889

Approvals: Process Plan: WFE Date: 14-10-06 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-760	G								

100

100

QC

Quality Control

Memo

INSPECT RA 111889
D412-760-113 X 1 B97344

KIT IS COMPLETE
ID AND STOCK UNDER NEW BATCH NUMBER

0.00

110

110

Packaging

Packaging

Memo

Identify as per dwg & Stock Location: S1500 0.00

0.00

SCRAP

parts were
scrapped
return rest
of parts/hardware
under
original
#number

14-11-27 PD

PTO →

DEC 05 2014

DQA:

Date: 15/06/16



QA Closed:

Date: 15/06/11

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 118461	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. D412-760-113		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. 15-5087		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☒
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				D3933-1 / D3933-2		D3933-1 + D3933-2			
Doc/Data				was scratch during		scrap & destroy			
Equip/Tooling				handling.		Replaced			
Handling/Pre						D3933-1			
Material				RC parts were		D3933-2			
Operator				store in a		restock rest of kit			
Offset/Setup				unprotected place		in store			
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☒ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Revision ID:

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Customer: CHAWK02

Reference: RMA RA111889

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC21- Final Inspection - Work Order Release

0.00

120

QC

Memo

0.00

Quality Control

Ø.
me
14-12-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Equip/Tooling									
Handling/Pre									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, December 05, 2014 12:58:12 PM

Page 1

Work Order ID: 118461

118461

Parent Item: D412-760-113

D412-760-113

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 10/6/2014

Required Date: 10/7/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3935-3 Manufactured No

Each 3.0000 -1

D3935-3

Pylon Wall

Location	Loc Qty	Loc Code
----------	---------	----------

PKG	2	
-----	---	--

120435	2	
--------	---	--

ST500	1	
-------	---	--

96834	1	
-------	---	--

Each 4.0000 -1

D3935-4 Manufactured No

D3935-4

Pylon Wall

Location	Loc Qty	Loc Code
----------	---------	----------

PKG	2	
-----	---	--

120130	2	
--------	---	--

ST201B	1	
--------	---	--

97357	1	
-------	---	--

ST500	1	
-------	---	--

97358	1	
-------	---	--

Each 16.0000 -14

D3942-1 Manufactured No

D3942-1

Angle

Location	Loc Qty	Loc Code
----------	---------	----------

ST068	16	
-------	----	--

108869	2	
--------	---	--

96836	14	
-------	----	--

MF 14-12-05

MF 14-12-05

MF 14-12-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, December 05, 2014 12:58:12 PM

Work Order ID: 118461

118461

Parent Item: D412-760-113

D412-760-113

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 10/6/2014

Required Date: 10/7/2014

Start Qty: 1.00

Required Qty: 1.00

D3942-3 Manufactured No

Each 10.0000 -10

D3942-3

Clip

Location

Loc Qty

Loc Code

ST068

10

94910

10

Each

1.0000

MF 14-12-05

1

D412-760-113

Manufactured No

D412-760-113

Aft Cabin Wall & Pylon Protector

Location

Loc Qty

Loc Code

FG040

1

120310

1

Each

20.0000

97344 MF 14-12-05

-4

MS27039-4-10

Purchased No

MS27039-4-10

Screw

Location

Loc Qty

Loc Code

ST283

20

14742

4

124552

16

Each

46.0000

MF 14-12-05

-6

MS27039-4-14

Purchased No

MS27039-4-14

SCREW

Location

Loc Qty

Loc Code

ST283

46

124552

6

m130716

11

m131049

29

MF 14-12-05

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID: 118461

118461

Parent Item: D412-760-113

D412-760-113

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 10/6/2014

Required Date: 10/7/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-5-08

Purchased

No

Each

6.0000

-6

MS27039-5-08

Screw

Location

Loc Qty

Loc Code

ST282

6

124185

6

Each

60.0000

-8

MF 14-12-05

MS27039-5-12

Purchased

No

MS27039-5-12

Screw

Location

Loc Qty

Loc Code

ST282

60

124604

9

m131049

51

MF 14-12-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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RA 111889

Received @ Dart September 30th, 2014
Inspected @ Dart October 3rd, 2014

CUSTOMER: HAWKER PACIFIC AUSTRALIA
CUSTOMER CONTACT: AMY GWAN
SHIPPED FROM: YAGOONA N.S.W AUSTRALIA

Instructions for RA 111889

- ~~D412-760-113 B97344~~ CHG 002-
 - Kit complete
 - Needs new labels & paper works
 - Return to stock under new Batch #
- ~~D3575-1 B94903 Rev A~~-
 - Return to stock as is under new Batch #
 - Clean all plastic of dirt / grime
 - Remove all original part markings
 - **USE NON HARMFUL CLEANERS**
 - Re-identify under new Batch # and part #'s
- ~~D3575-2 B94904 Rev A~~-
 - Return to stock as is under new Batch #
 - Clean all plastic of dirt / grime
 - Remove all original part markings
 - **USE NON HARMFUL CLEANERS**
 - Re-identify under new Batch # and part #'s

Time Estimate = 1 HOUR

Departments Required: Store & QC

Pictures Attached = N/A

QTY INSPECTED = x1 D412-760-113 B97344

x1 D3575-1 B94903

x1 D3575-2 B94904

**HIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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FAULT CATEGORY

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